

Date: Thursday, 2/7/2008 10:54:23 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 37284	
Estimate Number : 10533	
P.O. Number :	Part Number : D2573
This Issue : 2/7/2008 S.O. No. :	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 36324	Material :
Written By : <u>                    </u>	Due Date : 2/28/2008 Qty: 12 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101007	7075-T7351 8.25X7.75X2.5
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: B34875

                     08/02/27

(12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 37284 Double check by:                     

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

                     08/03/17

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

                     08/03/17

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

                     08/03/17

(12)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 28/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/7/2008 10:54:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37284

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2F 08/03/14

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/03/18

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BL 08-03-19

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-19

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 433

8/3/19 SP

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dec 03/00

Job Completion



U 8-0320

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37284
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.004	8.004	8.004		
F	0.490	0.510		.501	.505	.500	.500		
G	0.257	0.262	<del>DT8683</del>	.260	.260	.260	.260		
H	0.375	0.380	<del>DT8684</del>	.378	.378	.378	.378		
I	0.490	0.510		.502	.499	.502	.502		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.570	.566	.569	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.128	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.253	.253	.253		
S	0.115	0.135		.128	.126	.128	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.229		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.129	.130	.127	.127		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.367	.369	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.625	.624	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.251	.247		
AE	1.500	1.520		1.512	1.513	1.512	1.512		
AF	0.115	0.135		.125	.127	.125	.125		
AG	0.240	0.280		.265	.260	.265	.263		
AH	0.240	0.260		.250	.249	.251	.250		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SN / [Signature]
Date:	08/03/15

Audited by:	RF
Date:	08/03/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37284
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.001	8.001	8.001		
F	0.490	0.510		.500	.502	.501	.503		
G	0.257	0.262	<del>DT8683</del>	.260	.260	.260	.260		
H	0.375	0.380	<del>DT8684</del>	.376	.378	.378	.378		
I	0.490	0.510		.504	.502	.502	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.572	.570	.569	.578		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.127	4.122	4.123	4.122		
P	0.115	0.135		.128	.126	.126	.125		
Q	0.115	0.135		.135	.135	.133	.135		
R	0.240	0.260		.255	.252	.253	.257		
S	0.115	0.135		.126	.129	.130	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.227		
V	0.230	0.250		.242	.241	.242	.241		
W	0.115	0.135		.125	.128	.128	.130		
X	0.308	0.313		.310	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.358	.357	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.624	.621	.621		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.255	.247	.252		
AE	1.500	1.520		1.515	1.513	1.514	1.513		
AF	0.115	0.135		.135	.132	.125	.126		
AG	0.240	0.280		.260	.260	.260	.264		
AH	0.240	0.260		.251	.250	.252	.257		
AI	2.000	2.020		2.004	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SA/3me
Date:	08/03/17

Audited by:	RF
Date:	08/03/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37284
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.003	8.004		
F	0.490	0.510		.504	.504	.504	.502		
G	0.257	0.262	<del>DT8683</del>	.260	.260	.260	.260		
H	0.375	0.380	<del>DT8684</del>	.378	.378	.378	.378		
I	0.490	0.510		.499	.502	.503	.502		
J	1.174	1.184		1.179	1.180	1.179	1.179		
K	0.558	0.578		.567	.569	.570	.568		
L	1.174	1.184		1.179	1.180	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.125	.134	.132	.131		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.257	.256	.255		
S	0.115	0.135		.130	.121	.127	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.227	3.228	3.230		
V	0.230	0.250		.242	.230	.230	.231		
W	0.115	0.135		.132	.119	.120	.121		
X	0.308	0.313		.308	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.627	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.244	.245	.248		
AE	1.500	1.520		1.509	1.519	1.518	1.518		
AF	0.115	0.135		.125	.127	.125	.125		
AG	0.240	0.280		.265	.260	.265	.265		
AH	0.240	0.260		.253	.245	.249	.250		
AI	2.000	2.020		2.000	2.007	2.008	2.008		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	gml
Date:	08/03/17

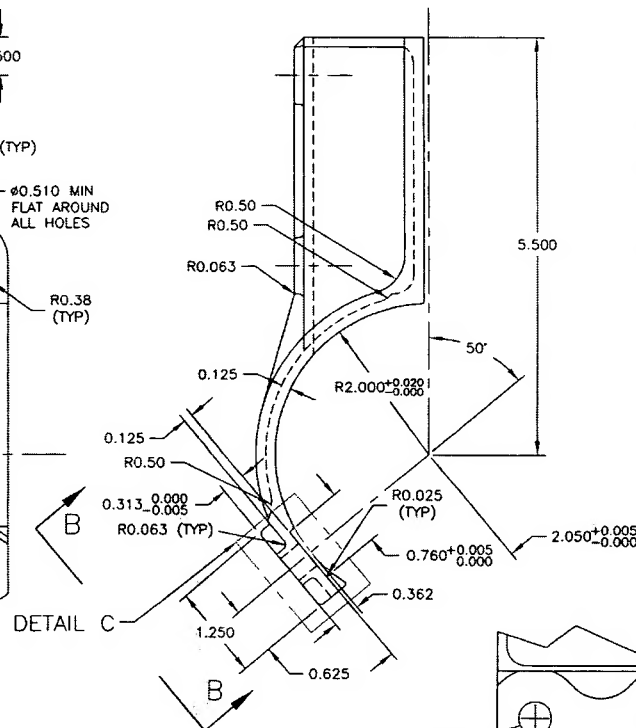
Audited by:	RF
Date:	08/03/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	








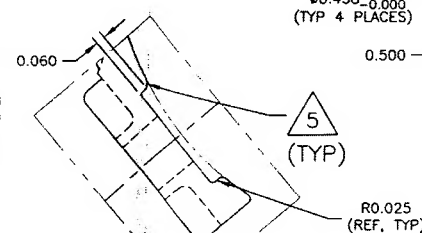


05.12.06






MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |



DETAIL C  
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> <small>HARRISBURY, ONTARIO, CANADA</small>
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2573
DATE		TITLE
05.07.13		OUTER AFT SADDLE
		SCALE
		2:

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37284